

Date: Friday, 29/05/2009 3:47:14 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASSEMBLY
Job Number :	48299B		
Estimate Number :	10207		
P.O. Number :		Part Number :	D2989043
This Issue :	29/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2989 REVD
First Issue :	29/05/2009	Project Number :	N/A
Previous Run :	48298B	Drawing Revision :	D
		Material :	
Written By :		Due Date :	08/06/2009
Checked & Approved By :	Qty: 1 Um: Each		
Comment :	Est Rev:I Removed D2989-041 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC Est Rev:L 08-12-02 revD as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	D29893	Rib
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B44770</u> PD 09.06.08		

✓ 2.0	D29894	Rib
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B44769</u> PD 09.06.08		

✓ 3.0	D29895	Rib
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B44768 → 1 B45606 → 1</u> PD 09.06.08		

✓ 4.0	D22211	Rib
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48101</u> PD 09.06.08		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/05/2009 3:47:14 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 48299B

Part Number: D2989043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D31821	Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hinge

batch: B45504

PD 09.06.08

6.0	D34423	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B45607

PD 09.06.08

7.0	D3827041	Rib Assembly (Inboard)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B48100

PD 09.06.08

8.0	D38325	Mesh (Lid)
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Lid)

batch: B44766

PD 09.06.08

9.0	D38335	Mesh (Lid End)
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Lid End)

batch: ~~46307~~ ~~46767~~ B44767

SM 09/06/10

10.0	D3838041	Rib Assembly (Basket Lid, LH)
------	----------	-------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Basket Lid, LH)

batch: B44772

PD 09.06.08

11.0	D3838042	Rib Assembly (Basket Lid, RH)
------	----------	-------------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Basket Lid, RH)

batch: B44773

PD 09.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 29/05/2009 3:47:14 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 48299B

Part Number: D2989043

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- assemble all ribs in DT9446 jig, weld as per dwg D2989
 - 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
 - 3- to locate hinges and shims use D2989-041, weld as per dwg D2989
- A/R ER316 S.S. Rod Batch: M1081160

PD 09.06.08 / SH 09/06/10

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Lp 09.06.11

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09.06.11 (C)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

- 1- Plug holes prior to powder coating

PRESS WASH BR 09-06-11 (P)

- 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME: 3:15pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:45pm

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 7:00am

OVEN TEMPERATURE: 400°F

FINISH TIME: 7:20am

SH 09-06-12 (X)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

FX 09/06/15 (V)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASSEMBLY

Job Number: 48299B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/18 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

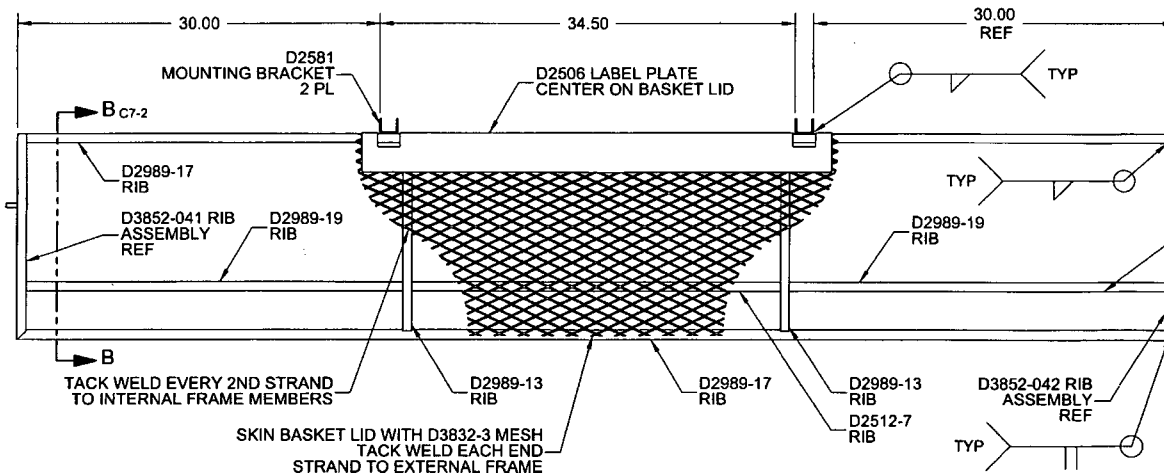
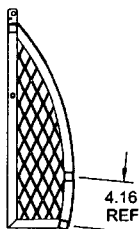
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3838-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2. REMOVED D2327-3 (NOW INSTALLED ON D3838 DWG); D2989-9/-10 (NOW ON D3838 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.050 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDM
WITHOUT NOTIC
WORK ORDER
NO. 18-0005

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SECTION B-B

D7-2



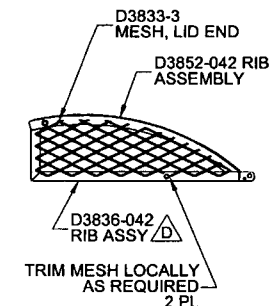
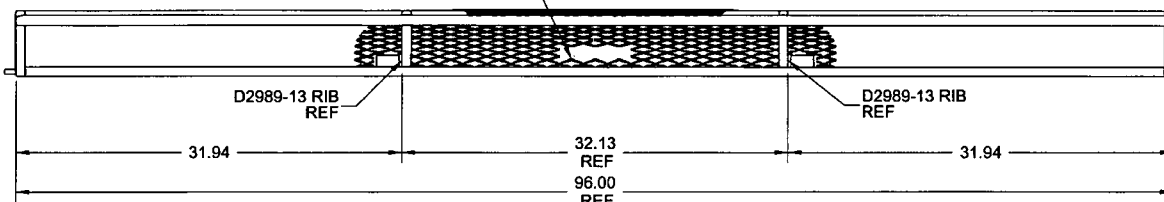
TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID
PAINT THIS SECTION

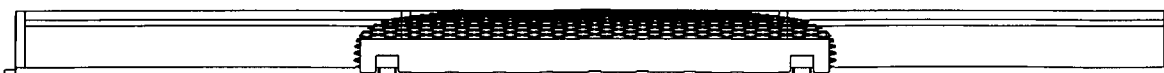
SKIN BASKET LID WITH D3832-3 MESH
TACK WELD EACH END
STRAND TO EXTERNAL FRAME

TACK WELD EVERY 2ND STRAND
TO INTERNAL FRAME MEMBERS

TACK WELD MESH TO LABEL PLATE
AT EVERY AVAILABLE LOCATION



D2989-041 BASKET LID ASSEMBLY (MESH SHOWN LOCALLY FOR CLARITY)



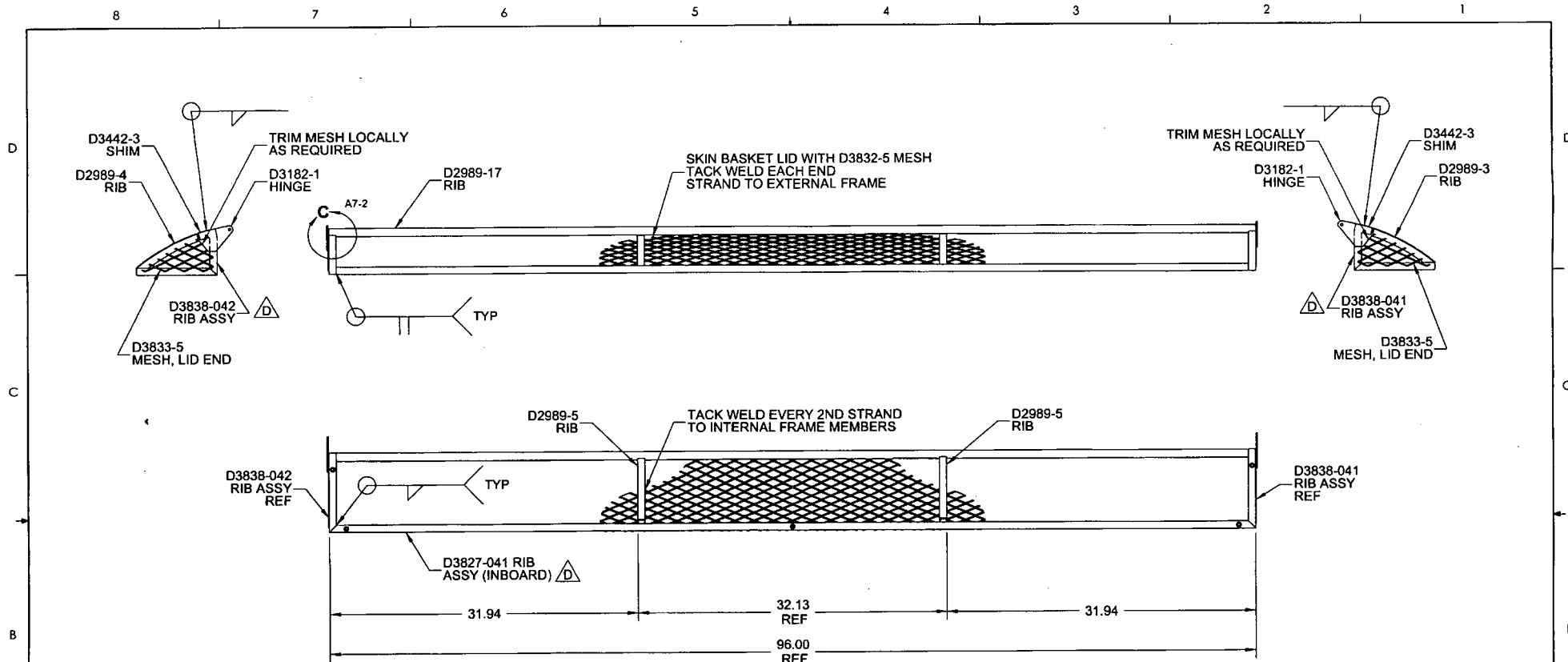
VIEW A:A B8-2

2 PL
FILL NOTCH
WITH WELD
9 PL

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08/11/13

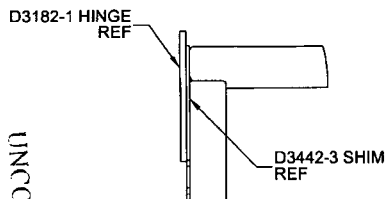
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY	SCALE
DE APPR.			NTS
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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

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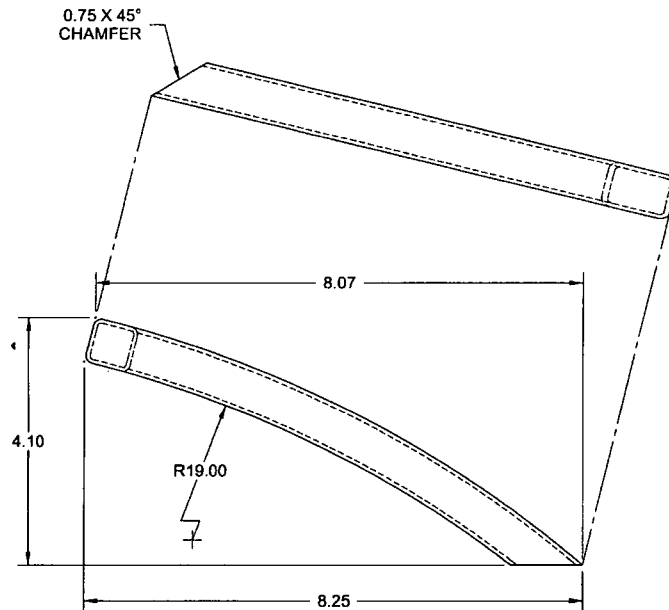


DETAIL C D7-2
TYP, SCALE 4X

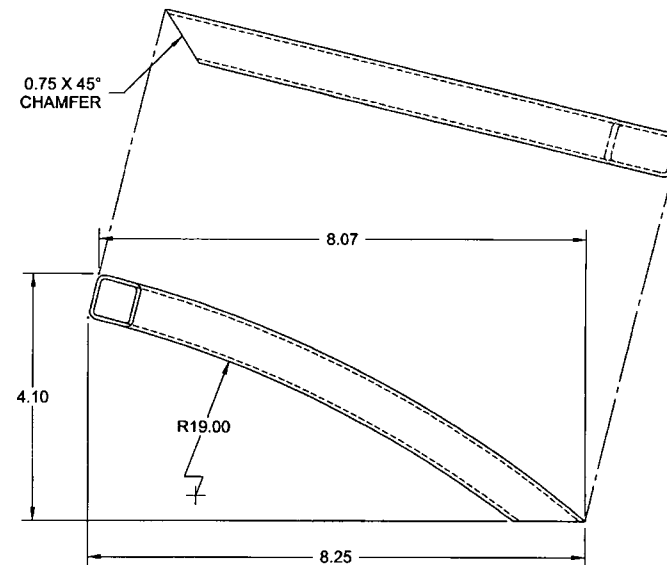
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY	SCALE NTS
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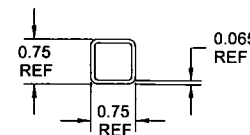
WORK ORDER



D2989-3 RIB



D2989-4 RIB






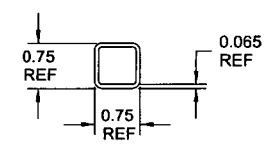
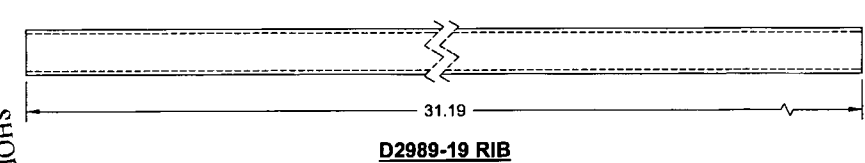
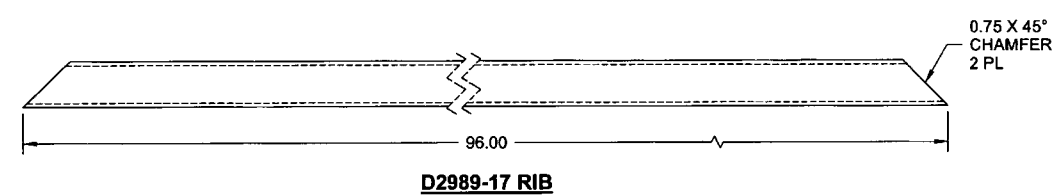
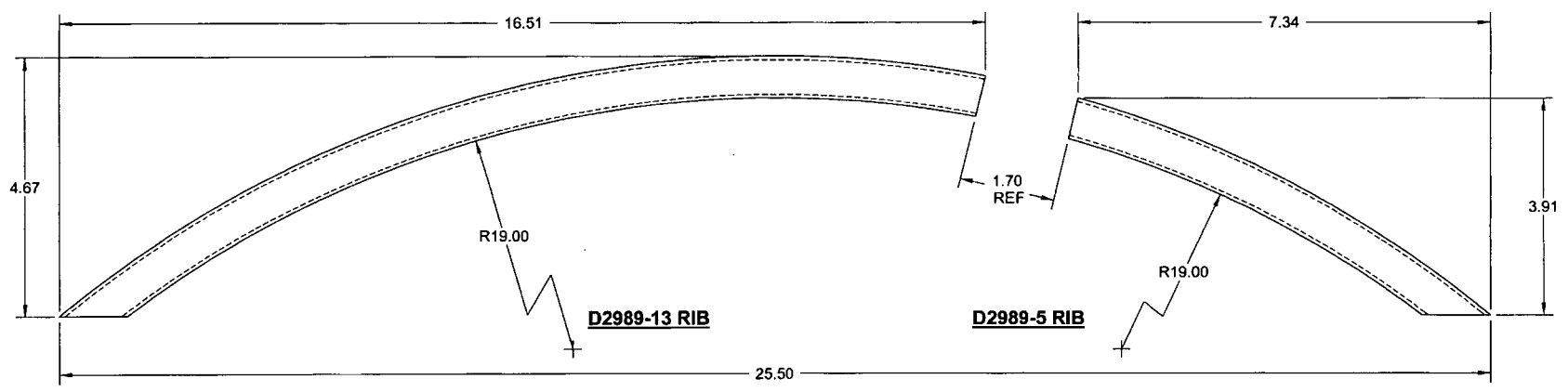
**TYPICAL SECTION
VIEW**

NO. 4782008
WORK ORDER
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- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	
DATE	08.09.24	NTS	
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TYPICAL SECTION VIEW

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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